

alu .750

Work Order ID 86865

86865

Page 1

July-06-12 3:17:47 PM

Item ID: D3492-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plug

Start Date: 7/06/12

Start Qty: 40.00

40

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: ✓Date: 12-07-10

Tooling:

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3492

D

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA632 & Dwg D3492

Dwg Rev: AA DFolio Rev: AADAS
14
2-89 12/07/2959 ✓

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS
14
2-89 12/07/2959 ✓

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

D.A 12/07/29

59 ✓

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 86865

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Page 2

July-06-12 3:17:47 PM

Item ID: D3492-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plug
 Start Date: 7/06/12 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 140 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | (Flat End Only) START TIME: 7:10 OVEN TEMPERATURE: 320°F FINISH TIME: 7:40 | | | | | | | | |
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

60 7/6 12-730

60X 12/08/01

60x 12/08/01

W121841

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 86865

86865

Page 3

July-06-12 3:17:47 PM

Item ID: D3492-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plug
 Start Date: 7/06/12 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | Identify as per dwg & Stock Location: <i>F-PA</i> | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/08/01

12/08/01

60X

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July-06-12 3:17:47 PM

Page 1

Work Order ID: 86865

Parent Item: D3492-3

Parent Item Name: Plug

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6R0.750 | | Purchased | No | | | 100 | f | 72.0630 | 0.06 | 2.526316 | | | |
| 6061-T6 Round Bar .750" | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT012 | 6.5 | |
| 120734 | 6.5 | |
| MAT013 | 65.563 | |
| 121282 | 5.563 | |
| 122081 | 60 | |

M120603 x 3.54

OK 12/07/29

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

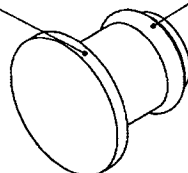
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | | | | | | | D3492-041 | PLUG ASSEMBLY |
| | X | | | | | | D3492-043 | PLUG ASSEMBLY |
| | | X | | | | | D3492-045 | PLUG ASSEMBLY |
| | | | X | | | | D3492-047 | PLUG ASSEMBLY |
| | | | | X | | | D3492-049 | PLUG ASSEMBLY |
| | | | | | X | | D3492-051 | PLUG ASSEMBLY |
| | | | | | | X | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | 1 | | | | | NAS1611-005 | O-RING |
| | | | 1 | | | | NAS1611-007 | O-RING |
| 1 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | 1 | NAS1611-012 | O-RING |
| | 1 | | | | | | NAS1611-013 | O-RING |
| | | | | | 1 | | NAS1611-015 | O-RING |
| | | | | 1 | | | NAS1611-016 | O-RING |

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 84865
12-07-10

RELEASED
2011-05-30

| | | | |
|--|---|--|--------------|
| D | INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048) | AJS | 11.05.24 |
| C | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047; UPDATE DIM A FOR -045 | PH | 08.05.11 |
| A | NEW ISSUE | PH | 08.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | J.F. | DRAWING NO. | REV. D |
| MFG. APPR. | J.F. | D3492 | SHEET 1 OF 2 |
| APPROVED | AJS | TITLE | SCALE |
| DE APPR. | J.F. | PLUG | 2:1 |
| DATE | 11.05.24 | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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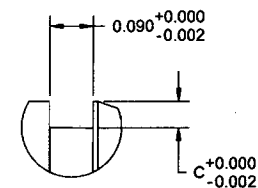
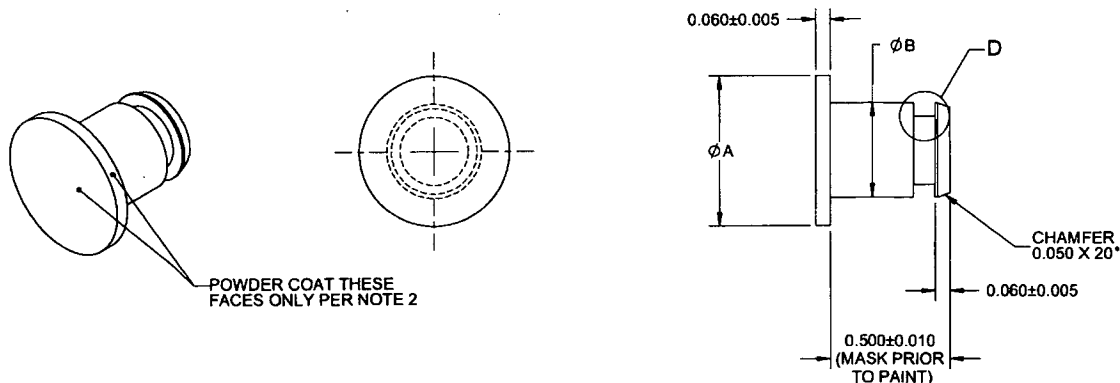
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC | |
|----------|-------|-------|-------|---------------|---|
| D3492-1 | 0.625 | 0.394 | 0.050 | M6061T6R0.625 | △ |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 | |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 | |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 | |
| D3492-9 | 0.938 | 0.750 | 0.045 | M6061T6R1.000 | |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 | |
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 | △ |

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

86845

RELEASED
2011-05-30

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | JES | DRAWING NO. D3492 | REV. D |
| MFG. APPR. | | | SHEET 2 OF 2 |
| APPROVED | | TITLE PLUG | SCALE 4:1 |
| DE APPR. | | | |
| DATE | 11.05.24 | COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

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